Thursday, 4/12/2007 9:33:44 AM

User:

Kim Johnston

## **Process Sheet**

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 31785

Estimate Number

: 10826

P.O. Number This Issue

: 1/4

4/12/2007

Prsht Rev. First Issue

Previous Run

Written By

Comment

: NC : NA : 30876

Type

: Est. F 05.11.02

S.O. No. : NA

: MACHINED PARTS

Removed 303 SS

Project Number

KJ/EC

**Drawing Revision** Material

**Drawing Number** 

**Drawing Name** 

Part Number

Due Date

: D23273

· D2327 REV D

: SPACER BUSHING

: N/A ; D

: N/A

: 4/28/2007

50 Um:

Each

Additional Product

Checked & Approved By

Job Number:

Seq. #:

Machine Or Operation:

Description:

1.0

M304R0375

304 SS ROUND BAR



Comment: Qty.:

0.1641 f(s)/Unit

Total:

8.2058 f(s)

Inventory

Material: AISI 304 Round Bar Ø0.375"

(M304R0.375)

Batch: 107301

2.0

HARDINGE

HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL Turn per Folio FA232 and Dwg D2327

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



3.0



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

PACKAGING 1

PACKAGING RESOURCE #1





Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:



Dart Aerospac	e:	Ltd
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W/O:		WORK ORDER CHANGES										
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
Port No	_	DAD # Coult Cotomon		<u> </u>	. 🔾	Dota :	=1 -1					

Part No:	PAR #:	Fault Category:	 NCR: Yes No	DQA:	Date: 0//05/11
			QA: N/C C	losed:	Date:

NCR:	R: WORK ORDER NON-CONFORMANCE (NCR)							
	7	Description of NC		Corrective Action Section B		Varification	Approval Chief Eng	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C		Approval QC Inspector

NOTE: Date & initial all entries

Date:

Thursday, 4/12/2007 9:33:44 AM

User:

Kim Johnston

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER BUSHING

Job Number: 31785

Part Number: D23273

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 07.05.09

W/O: WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANG	3E	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		·						
Part No		PAR #: Fault Catego	ry: NCR:	Yes	No DQ	۱:	Date:	
				QA: N	V/C Closed	l:	Date:	

NCR:	:	WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action Section B		Verification	Annessal	Ammercal	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector	
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31785
Description: Spacer Bushing	Part Number:	D2327-3
Inspection Dwg: D2327 Rev: D		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.375	+0.005/-0.000	.375	<u></u>			
Ø0.257	+0.005/-0.000		-		-	
1.750	+/-0.010	1,750				
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424						

Measured by:	Audited by:	MS	Prototype Approval:	N/A
Date: 07/05///	Date:	0-105/11	Date:	N/A

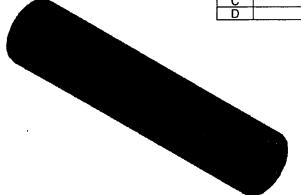
Rev	Date	Change	Revised by	Approved
Α	04.01.13	New Issue	KJ/RF	
В	06.11.24	Dwg Revision revised	KJ/JLM	B

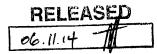
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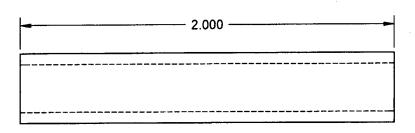


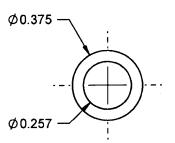
	DESIGN BW	DRAWN BY	DART AEROSPACE LTD		
	BAA		HAWKESBURY, ONTARIO,	, CANADA	
	CHECKED	APPROVED	DRAWING NO.	REV. D	
	LE	9A	D2327	SHEET 1 OF 1	
	DATE 06.10.12		TITLE	SCALE	
			SPACER BUSHING	2:1	

		06.10.12	SPACER BUSHING	2:1
1	REV	DATE	DESCRIPTION	
	A	94.12.17	NEWISSUE	
	В	95.12.06	LENGTH CHANGE	
	С	03.05.13	303 SS SPEC ADDED	
	D	06 10 12	REMOVE 303 SS MATERIAL	

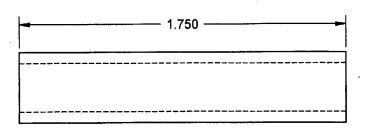


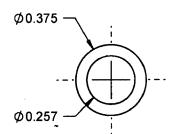






## D2327-1 SPACER BUSHING





## **D2327-3 SPACER BUSHING**

SHOP COPY RETURN TO

**ENGINEERING** NOTES:
1) MATERIAL: AISI 304/316 SS, Ø0.375, 0.065 WALL SEAMLESS ROUND TUBINGING ONTROLLED COPY SUBXIDY TO AMENDMENT (REF. DART SPEC M304TR0.375W.065)

2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

5) BREAK ALL SHARP CORNERS TO 0.010 MAX

WITHOUT NOTICE

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